

Date: Wednesday, 01/04/2009 2:28:49 PM
User: Linda Lacelle

Process Sheet

split

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : X-TUBE EXTRUSION
Job Number : 46779 - 2	
Estimate Number : 11108	
P.O. Number :	Part Number : D6008180
This Issue : 01/04/2009 S.O. No. :	Drawing Number : D6008 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / /	Drawing Revision : A
Previous Run : 40271	Material :
Written By :	Due Date : 30/04/2009
Checked & Approved By :	Qty: 10 Um: Each
Comment : Est Rev:C 04.06.18 Added tolerance to Step 2 KJ/JLM	

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O:

8484

u 08-04-01

- a) Order as per Dwg D6008
- b) Material: 3.250 x 0.438 wall 7075-T6/T6511 (WW-T-700/7 or QQ-A-225/9 or QQ-A-200/11) seamless aluminum tube
- c) Minimum ultimate tensile strength = 77 ksi
- d) Minimum tensile yield strength = 66 ksi
- e) Tolerance are per ASTM B210 (see details on Dwg D6008)
- f) Material certification required

2.0 D6008180P Crosstube extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total: 15.0000 Each(s)
Crosstube extrusion

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Receive & Inspect For Transit Damage
Ensure material certification is attached

24/4/8 *(u)*

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK
Ensure Material certification comply to Dwg D6005

10/06/11 *(u)*

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Drawing Name: X-TUBE EXTRUSION

Job Number: 46779

Part Number: D6008180

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



AWM 9-6-12



(10)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10
09-06-15

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

BACK HALL (PARK)

AWM
9-6-15

(10)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/15

Job Completion



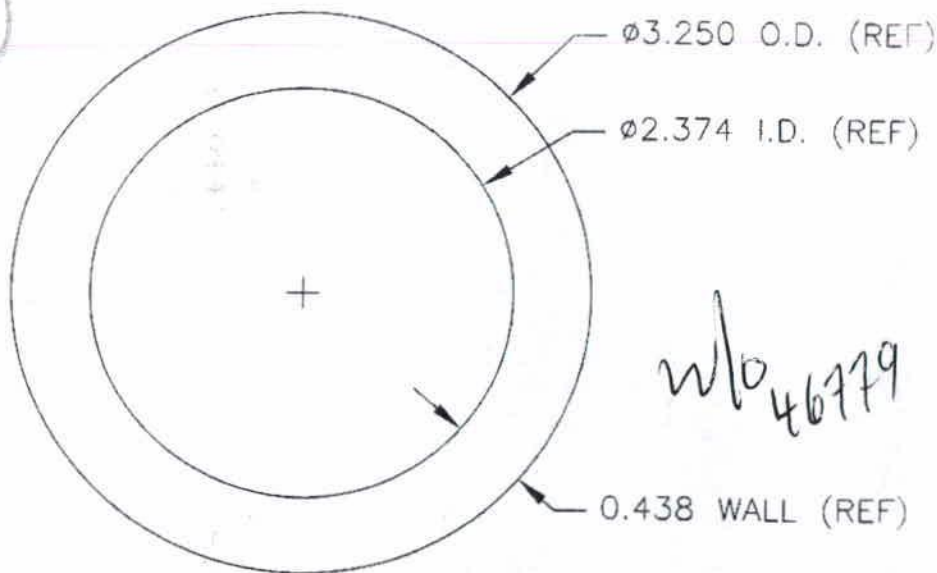
mf
09-06-15



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D6008	REV. A SHEET 1 OF 1
DATE 00.11.17		TITLE CROSSTUBE MATERIAL	SCALE 1:1
A	00.11.17	NEW ISSUE	

SPECIFICATION CONTROL DRAWING

RELEASED
02-11-24



NOTES

- 1) D6008-XXX CROSSTUBE
LENGTH

WHERE XXX IS LENGTH IN INCHES
EG. 180" LONG TUBE: D6008-180

- 2) MATERIAL: 3.250 OD x 0.438 WALL 7075-T6/T6511 (WW-T-700/7 OR QQ-A-225/9 OR QQ-A-200/11) SEAMLESS ALUMINUM TUBE.
MINIMUM ULTIMATE TENSILE STRENGTH = 77 ksi
MINIMUM YIELD TENSILE STRENGTH = 66 ksi
- 3) TOLERANCES ARE PER ASTM B210 AS FOLLOWS:
O.D.: ± 0.008 MEAN (± 0.016 INCLUDING OVALITY)
WALL: ± 0.020 MEAN (± 0.044 INCLUDING ECCENTRICITY)
LENGTH: XXX $+0.125/-0.000$
STRAIGHTNESS: 0.010" DEVIATION / 12" LENGTH
- 4) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 5) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

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Abnahmeprüfzeugnis 3.1 - EN 10204:2004

Inspection Certificate 3.1 - EN 10204:2004 / Certificat de Reception 3.1- EN 10204:2004

Kunde: Dart Aerospace Ltd.

Client:

1270 Aberdeen Street
K6A1K7 Hawkesbury, ON Canada

Zeugnisnummer: 483/09

Cert No.: / No. du certificat:

PO 00008484

Bestellnummer:

Order No. / No. de commande

Auftrag:

32365/1

Our Reference/Notre Reference:

Produkt:

Product / Produit:

Rohre nahtlos gepresst

Tubes seamless extruded

Spezifikation:

Specification:

AMS - QQ - A - 200/11; AMS - WW - T 700/7; Spezifikation Dart Aerospace D6003

Werkstoff:

Alloy/Alliage:

7075

Zustand:

Temper/État

T 6511

Abmessung

Size / Dimension

3,250 INCH x 2,374 INCH x 0,438 INCH x 180,000 INCH

D6008-180 3.250 x 0.438 x 180

Kennzeichnung

Marking/Marquage:

ALUnna-Cert No.483/09-7075-T6511-Cast No.2674-AMS-QQA-200/11-3.250" Od X 0.438" Wall-Heat Lot No.400032-

Alunna Order Conf .No.32365/1-1-P.O.00008484

Lieferung

Delivered Material / Matériel délivré:

pcs.

lbs

Country of Manufacture: Germany

10

705

1. Chemische Analyse

Chemical Analysis / analyse chimique

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Pb	Zr	Bi	Sn	Ni
Charge/ min.			1,2		2,1	0,18	5,1						
Cast No. max.	0,40	0,50	2,0	0,30	2,9	0,28	6,1	0,20					
2674/09	0,093	0,210	1,396	0,047	2,395	0,195	5,663	0,036	0,001	0,0209	0,0001	0,0009	0,0001

Hydrogen content: 0,14

ccm/100 g Al Elements without indication < 0,01 %

country of melt manufacturer: Germany

2. Mechanische Eigenschaften

Mechanical Properties / Valeurs Mécaniques

Anforderungen Requirements	tensile (Rm) ksi	yield (Rp0,2) ksi	elongation 2" %	elongation A %	Hardness HB	Heat Lot No.
min.	77,0	66,0				
max.						
1	84,245 ✓	77,140 ✓	9,0 ✓			400032 - 10 pcs. ↑

RMS: outside 25 - max. 11,5 µ"

**Ergebnis der
Prüfungen:**

Es wird bestätigt, daß die Lieferung geprüft wurde und den Vereinbarungen bei der Bestellannahme entspricht

Test results:

We confirm that the delivery has been tested and applies to the agreements made on receipt of the order

Resultats:

Nous confirmons que la livraison a été contrôlée et correspond avec les conventions faites à la réception de la commande